



**AIR POLLUTION CONTROL
MINOR SOURCE
PERMIT TO OPERATE**

Pursuant to Chapter 23-25 of the North Dakota Century Code, and the Air Pollution Control Rules of the State of North Dakota, and in reliance on statements and representations heretofore made by the owner designated below, a Permit to Operate is hereby issued authorizing such owner to operate the source unit(s) at the location designated below. This Permit to Operate is subject to all applicable rules and orders now or hereafter in effect of the North Dakota Department of Health and to any conditions specified below:

1. Permittee: A. Name: CHS, Inc. B. Address: P.O. Box 909 Laurel, MT 59044	2. A. Permit Number: O96011 Renewal No.: 2 Revision No.: 0 B. Permit Description: Synthetic Minor Source: NDAC 33-15-14-03.1.e
3. Source Name & Location: Minot Pipeline Terminal SE¼, Sec. 20, T155N, R83W 4 miles West of Minot, North Dakota Ward County	4. Source Type: Fuel Terminal
5. Expiration Date: <div style="text-align: right; margin-top: 10px;">August 9, 2021</div>	
6. Source Unit(s):	

Emission Unit Description	Emission Unit (EU)	Emission Point (EP)	Air Pollution Control Equipment
One 25,615-barrel (1,117,830 gallon) external floating roof gasoline storage tank (1960)	Tank 201	2	External Floating Roof (EFR) & Submerged Fill Pipe (SFP)
One 54,000-barrel (2,268,000 gallon) external floating roof gasoline storage tank (1960)	Tank 202	3	EFR & SFP
One 30,000-barrel (1,260,000 gallon) fixed roof distillate oil storage tank (1960)	Tank 203	4	SFP
One 30,000-barrel (1,260,000 gallon) fixed roof distillate oil storage tank (1960)	Tank 204	5	SFP
One 30,000-barrel (1,260,000 gallon) fixed roof distillate oil storage tank (1960)	Tank 205	6	SFP

Emission Unit Description	Emission Unit (EU)	Emission Point (EP)	Air Pollution Control Equipment
One 2,500-barrel (105,000 gallon) fixed roof ethanol storage tank (1960)	Tank 206	7	SFP
One 2,500-barrel (105,000 gallon) fixed roof slop storage tank (1960)	Tank 207	8	SFP
One 54,000-barrel (2,268,000 gallon) external floating roof gasoline storage tank (1960)	Tank 208	9	EFR & SFP
One 54,000-barrel (2,268,000 gallon) external floating roof gasoline or distillate oil storage tank (1968)	Tank 209	10	EFR & SFP
One 54,000-barrel (2,268,000 gallon) external floating roof gasoline storage tank (1974) (Subpart K)	Tank 210	11	EFR & SFP
One 130,000-barrel (5,460,000 gallon) internal floating roof gasoline or distillate oil storage tank (2011) (Subpart Kb)	Tank 211	12	IFR & SFP
One 130,000-barrel (5,460,000 gallon) internal floating roof gasoline or distillate oil storage tank (2011) (Subpart Kb)	Tank 212	13	IFR & SFP
One 250,000-barrel (10,500,000 gallon) cone-roofed distillate oil (#1 or #2 diesel) tank	Tank 214	15	SFP
One 10,000-barrel (420,000 gallon) ethanol tank (Subpart Kb)	Tank 215	16	IFR & SFP
One 10,000-barrel (420,000 gallon) transmix (gasoline/diesel mix) tank (Subpart Kb)	Tank 216	17	IFR & SFP
One four-spot loading rack	1	14	VCU
John Zink vapor combustion unit (VCU)	2	14	None

CONDITIONS

7. A. **Emission Limits:** Emission limits from the operation of the source unit(s) identified in item 6 of this Permit to Operate (hereafter referred to as "permit") are as follows. Source units not listed are subject to the applicable emission limits specified in the North Dakota Air Pollution Control Rules.

Emission Unit Description	EU	EP	Pollutant/Parameter	Emission Limit
John Zinc vapor combustion unit	2	14	Opacity	20% (40%*)

* Permissible for not more than one six-minute period per hour.

- B. **Product Throughput Limits:** The amount of gasoline transferred through the loading rack at the facility shall not exceed 360,000,000 gallons (8,571,428 barrels) in any rolling 12-month period. The amount of diesel fuel transferred through the loading rack at the facility shall not exceed 350,000,000 gallons (8,333,333 barrels) in any rolling 12-month period.

- C. **New Source Performance Standards (NSPS) for Storage Tank(s):** The owner/operator shall operate the storage tanks in accordance with the following applicable requirement(s):
- 40 CFR 60, Subpart K - Standards of Performance for Storage Vessels for Petroleum Liquids for Which Construction, Reconstruction or Modification Commenced After June 11, 1973, and Prior to May 19, 1978, as incorporated by reference into NDAC Chapter 33-15-12.
 - 40 CFR 60, Subpart Kb - Standards of Performance for Volatile Organic Liquid Storage Vessels (including Petroleum Liquid Storage Vessels) for which Construction, Reconstruction or Modification Commenced after July 23, 1984, as incorporated by reference into NDAC Chapter 33-15-12.
- D. **40 CFR 60, Subpart XX (2X):** The owner/operator shall comply with all applicable requirements of 40 CFR 60, Subpart 2X – Standards of Performance for New Stationary Sources, Standards of Performance for Bulk Gasoline Terminals. Any facility to which a 40 CFR 60 subpart applies is also subject to 40 CFR 60 Subpart A – General Provisions.

Subpart 2X requirements include but may not be limited to:

- 1) Vapor Collection System Limit: Emissions to the atmosphere from the vapor collection system due to the loading of liquid product in tank trucks shall not exceed 35 milligrams of total organic compounds per liter of gasoline loaded.
- 2) Design and Operating Requirements:
 - a) The loading of liquid product into tank trucks shall be limited to vapor tight tank trucks using procedures outlined in 40 CFR 60 Subpart XX Paragraph 60.502(e).
 - b) Loadings of tank trucks at the facility shall only be made into tanks equipped with vapor collection equipment that is compatible with the terminal's vapor collection system.
 - c) The terminal's and the tank truck's vapor collection systems shall be connected during each loading.
 - d) The vapor collection and liquid loading equipment shall be operated in such a manner to prevent gauge pressure in the delivery tanks from exceeding 4,500 pascals (450 mm of water) during product loading.
 - e) No pressure-vacuum vent in the vapor collection system shall begin to open at a system pressure less than 4,500 pascals (450 mm of water).
 - f) Each calendar month the vapor collection system, the vapor processing system, and the loading rack shall be inspected during the loading of tank trucks for total organic compound liquid or vapor leaks using methods specified in 40 CFR Part 60 Subpart XX Paragraph 60.502(j).

3) Reporting and Recordkeeping Requirements:

- a) The owner/operator shall document and keep on file the following information as outlined in 40 CFR Part 60 Subpart XX Section 60.505:

- [1] Tank truck vapor tightness documentation that shall be updated at least annually.
- [2] Monthly leak check reports.

E. **Monitoring and Recordkeeping:** For tanks No. 210, 211 & 212, the owner/operator must maintain a record of the petroleum liquid stored, the period of storage, and the maximum true vapor pressure of that liquid during the respective storage period as required by 40 CFR 60, Subpart K and Kb.

- 1) On a monthly basis, the owner/operator must record the amount of gasoline transferred through the loading rack and calculate the amount of gasoline transferred on a rolling twelve-month period. The Department must be notified should the amount of gasoline transferred exceed 360 million gallons in any rolling 12-month period.
- 2) On a monthly basis, the owner/operator must record the amount of diesel fuel transferred through the loading rack and calculate the amount of diesel fuel transferred on a rolling twelve-month period. The Department must be notified should the amount of diesel fuel transferred exceed 350 million gallons in any rolling 12-month period.
- 3) The owner/operator shall maintain any compliance monitoring records required by the permit or applicable requirements. The owner/operator shall retain records of all required monitoring data and support information for a period of at least five years from the date of the monitoring sample, measurement, report or application. Support information may include all calibration and maintenance records and all original strip-chart recordings/computer printouts for continuous monitoring instrumentation, and copies of all reports required by this permit.

F. **40 CFR 63, Subpart BBBBBB (6B):** The owner/operator shall comply with all applicable requirements of 40 CFR 63, Subpart 6B – National Emission Standards for Hazardous Air Pollutants for Source Category: Gasoline Distribution Bulk Terminals, Bulk Plants, and Pipeline Facilities. For this subpart, EPA Region 8, not the North Dakota Department of Health, is the implementing and enforcement authority for area sources of HAP. Submit all documentation required by this subpart to EPA Region 8 at the following address:

Air Toxics Technical Enforcement Program (8ENF-AT)
Office of Enforcement, Compliance & Environmental Justice
U.S. EPA, Region 8
1595 Wynkoop Street
Denver, CO 80202-1129

G. **Storage Tanks:** The storage tanks shall be equipped with a submerged fill pipe in accordance with NDAC 33-15-07-01.3.


- H. **Organic Compounds Emissions:** The facility shall comply with the applicable requirements of NDAC 33-15-07, Control of Organic Compounds Emissions.
- I. **Fugitive Emissions:** The release of fugitive emissions shall comply with the applicable requirements in NDAC 33-15-17.
- J. **Annual Emission Inventory/Annual Production Reports:** The owner/operator shall submit an annual emission inventory report or an annual production report, upon request, on forms supplied or approved by the Department.
- K. **Source Operations:** Operations at the facility shall be in accordance with statements, representations, procedures and supporting data contained in the initial application, and any supplemental information or renewal application(s) submitted thereafter. Any operations not listed in this permit are subject to all applicable North Dakota Air Pollution Control Rules.
- L. **Alterations, Modifications or Changes:** Any alteration, repairing, expansion, or change in the method of operation of the source which results in the emission of an additional type or greater amount of air contaminants or which results in an increase in the ambient concentration of any air contaminant, must be reviewed and approved by the Department prior to the start of such alteration, repairing, expansion or change in the method of operation.
- M. **Recordkeeping:** The owner/operator shall maintain any compliance monitoring records required by this permit or applicable requirements. The owner/operator shall retain records of all required monitoring data and support information for a period of at least five years from the date of the monitoring sample, measurement, report or application. Support information may include all calibration and maintenance records and all original strip-chart recordings/computer printouts for continuous monitoring instrumentation, and copies of all reports required by the permit.
- N. **Air Pollution from Internal Combustion Engines:** The permittee shall comply with all applicable requirements of NDAC 33-15-08-01 – Internal Combustion Engine Emissions Restricted.
- O. **Nuisance or Danger:** This permit shall in no way authorize the maintenance of a nuisance or a danger to public health or safety.
- P. **Malfunction Notification:** The owner/operator shall notify the Department as soon as possible during normal working hours of any malfunction which can be expected to last longer than twenty-four hours and can cause the emission of air contaminants in violation of applicable rules and regulations. Immediate notification to the Department is required for any malfunction that would threaten health or welfare, or pose an imminent danger.
- Q. **Operation of Air Pollution Control Equipment:** The owner/operator shall maintain and operate all air pollution control equipment in a manner consistent with good air pollution control practice for minimizing emissions
- R. **Permit Renewal and Invalidation:** This permit shall be effective from the date of its issuance until the date specified in Item 5 unless sooner suspended, revoked or surrendered. Upon suspension or revocation, the permit shall be returned to the Department. Application for renewal of this permit

shall be submitted ninety days prior to such expiration date. The Department shall approve or disapprove the renewal of the permit within ninety days of receipt of the renewal application.

- S. **Change of Ownership:** This permit may not be transferred without prior approval from the Department.
- T. **Right of Entry:** Any duly authorized officer, employee or agent of the North Dakota Department of Health may enter and inspect any property, premise or place at which the source listed in Item 3 of this permit is located at any time for the purpose of ascertaining the state of compliance with the North Dakota Air Pollution Control Rules. The Department may conduct tests and take samples of air contaminants, fuel, processing material, and other materials which affect or may affect emissions of air contaminants from any source. The Department shall have the right to access and copy any records required by the Department's rules and to inspect monitoring equipment located on the premises.
- U. **Other Regulations:** The owner/operator of the source unit(s) described in Item 6 of this permit shall comply with all State and Federal environmental laws and rules. In addition, the owner/operator shall comply with all local burning, fire, zoning, and other applicable ordinances, codes, rules and regulations.
- V. **Permit Issuance:** This permit is issued in reliance upon the accuracy and completeness of the information set forth in the application. The conditions of this permit herein become, upon the effective date of this permit, enforceable by the Department pursuant to any remedies it now has, or may in the future have, under the North Dakota Air Pollution Control Law, NDCC Chapter 23-25. Each and every condition of this permit is a material part thereof, and is not severable.
- W. **Odor Restrictions:** The owner/operator shall not discharge into the ambient air any objectionable odorous air contaminant which is in excess of the limits established in NDAC 33-15-16.
- X. **Sampling and Testing:** The Department may require the owner/operator to conduct tests to determine the emission rate of air contaminants from the source. The Department may observe the testing and may specify testing methods to be used. A signed copy of the test results shall be furnished to the Department within 60 days of the test date. The basis for this condition is NDAC 33-15-01-12 which is hereby incorporated into this permit by reference. To facilitate preparing for and conducting such tests, and to facilitate reporting the test results to the Department, the owner/operator shall follow the procedures and formats in the Department's Emission Testing Guideline.

FOR THE NORTH DAKOTA
DEPARTMENT OF HEALTH

Date 9/14/16

By 
Terry L. O'Clair, P.E.
for Director
Division of Air Quality